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CLAIMS:

5 1. A cartridge for removably connecting to a cable useful to electrically connect a tow vehicle to a towed vehicle, the cartridge comprising:

 a nonconductive body having a first end and a second end and a plurality of openings extending from the first end
10 to the second end;

 an electrically conductive common contact member having a female contact end and an opposite contact end, wherein the female contact end is disposed in and the opposite contact end extends from a corresponding one of the plurality
15 of openings, and wherein the female contact end has an outer diameter that is smaller than an inner diameter of the corresponding body opening in which it is disposed to allow for a lateral movement of the female contact end within the body;

20 a plurality of electrically conductive noncommon contact members each having a female contact end and an opposite contact end, wherein each female contact end is disposed in and each opposite contact end extends from a corresponding one of the plurality of openings in the body,
25 and wherein each female contact end has an outer diameter that is smaller than an inner diameter of the corresponding body opening in which it is disposed to allow for a lateral movement of each female contact end within the body.

30 2. The cartridge of claim 1, wherein the first end of the body forms a plug-type moiety in conformity with SAE J560 and wherein the second end of the body forms a socket-type moiety substantially in conformity with SAE J560.

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3. The cartridge of claim 1, further comprising an end cap attached to the first end of the body, wherein the end cap comprises openings that correspond to and are aligned with each of the plurality of body openings, and wherein each end cap opening is smaller in diameter than an outer diameter of each female contact end to prevent each female contact end from axially extending beyond the first end of the body.

4. The cartridge of claim 3, wherein a junction between each female contact end and its corresponding opposite contact end forms a shoulder that engages a corresponding shoulder in the body opening in which the female contact end is disposed, such that each female contact end is axially constrained between the end cap and its corresponding body opening shoulder.

5. The cartridge of claim 1, wherein each female contact end comprises at least one longitudinal slot along at least a portion of its length to form a split sleeve, such that each female contact end comprises at least two moveable fingers.

6. The cartridge of claim 5, wherein each female contact end comprises a spring that biases the at least two moveable fingers of each female contact end towards each other.

7. The cartridge of claim 1, wherein each female contact end comprises a groove that receives a sealing element, such that the sealing element forms a seal between the female contact and the corresponding body opening in which the female contact is disposed.

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8. The cartridge of claim 1, wherein the second end of
5 the body comprises a projection extending therefrom, and
wherein the projection comprises a keying lug.

9. The cartridge of claim 1, wherein the body comprises
10 a length having a front end portion adjacent to the first end
of the body and a major portion extending from the front end
portion of the body to the second end of the body, and wherein
the front end portion has an outer diameter that is larger
than an outer diameter of the major portion of the length.

15 10. The cartridge of claim 1, wherein said opposite
contact end of the common contact member is a male contact and
wherein said wherein said opposite contact ends of each of the
noncommon contact members is a male contact.

20 11. A cable end plug assembly for removably electrically
connecting a tow vehicle to a towed vehicle comprising:
a cable having a plurality of wires disposed
therein;

a terminal electrically connected to each wire,
25 wherein each terminal includes a first contact end;

a first insulative body overmolded to the terminals
and a portion of the cable, such that the terminals and the
overmolded portion of the cable are embedded in the insulative
body, wherein the insulative body includes a first end having
30 openings corresponding to and aligned with each terminal, such
that the first end of the insulative body forms a first moiety
of a multicontact first electrical connector;

a removable cartridge comprising:

a second nonconductive body having a first end
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and a second end and a plurality of openings extending from the first end to the second end,

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an electrically conductive common contact member having a female contact end and an opposite contact end, wherein the female contact end is disposed in and the opposite contact end extends from a corresponding one of the plurality of openings, and

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a plurality of electrically conductive noncommon contact members each having a female contact end and an opposite contact end, wherein each female contact end is disposed in and each opposite contact end extends from a respective corresponding one of the plurality of openings, and
15 wherein the first end of the cartridge body forms a plug-type moiety of a second multicontact electrical connector and the second end of the cartridge body forms a second moiety of the first electrical connector, such that the cartridge forms a removable electrical connection with the first contacts of the
20 first insulative body when the cartridge is mated to the first insulative body; and

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a housing within which the first insulative body is disposed with the cable extending outwardly from one end of the housing, wherein the cartridge is removably mounted in an
25 open opposite end of the housing so that said opposite ends of the cartridge contacts engage the first contacts of the first insulative body and establish a connection between the first and second moieties of the first electrical connector within the housing.

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12. The cable end plug assembly of claim 11, wherein the first end of the first insulative body forms a plug-type moiety in conformity with SAE J560, the first end of the cartridge body forms a plug-type moiety in conformity with SAE

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J560 and the second end of the cartridge body forms a socket-type moiety substantially in conformity with SAE J560.

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13. The cable end plug assembly of claim 11, wherein the second end of the cartridge body comprises a projection extending therefrom that mates with a recess in the first end of the first insulative body to ensure a particular arrangement of said opposite contact ends of the cartridge contact members with respect to the first contact ends of the first insulative body terminals.

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14. The cable end plug assembly of claim 13, wherein the cartridge body projection comprises a keying lug that mates with a locating rib in the housing to ensure a particular orientation of the cartridge with respect to the housing.

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15. The cable end plug assembly of claim 11, wherein the cartridge body comprises a front end portion adjacent to the first end of the cartridge body and a major portion extending from the front end portion of the cartridge body to the second end of the cartridge body, and wherein the front end portion has an outer diameter that is larger than each of an outer diameter of the major portion and an inner diameter of the housing that receives the outer diameter of the major portion, such that the front end portion of the cartridge body extends from the housing when the housing is attached to the cartridge.

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16. The cable end plug assembly of claim 11, wherein the first insulative body comprises a flange adjacent to the first contact end of each terminal, and wherein each flange defines a diameter that is slightly smaller than an outer diameter of

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a corresponding one of said opposite contact ends of the cartridge contact members, such that when said opposite contact ends of the cartridge contact members are electrically connected to the first contact ends of the first insulative body terminals, each flange forms a seal with the outer diameter of a corresponding one of said opposite contact ends of the cartridge contact members.

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17. The cable end plug assembly of claim 11, wherein the female contact end of each contact member has an outer diameter that is smaller than an inner diameter of the corresponding cartridge body opening in which it is disposed to allow for a lateral movement of each female contact end within the body.

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18. The cable end plug assembly of claim 11, further comprising an end cap attached to the first end of the cartridge body, wherein the end cap comprises openings that correspond to and are aligned with each of the plurality of cartridge body openings, and wherein each end cap opening is smaller in diameter than an outer diameter of each female contact end to prevent each female contact end from axially extending beyond the first end of the cartridge body.

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19. The cable end plug assembly of claim 14, wherein a junction between each female contact end and its corresponding opposite contact end forms a shoulder that engages a corresponding shoulder in the cartridge body opening in which the female contact end is disposed, such that each female contact end is axially constrained between the end cap and its corresponding cartridge body opening shoulder.

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20. The cable end plug assembly of claim 11, wherein
each female contact end comprises a groove that receives a
sealing element, such that the sealing element forms a seal
between the female contact and the corresponding cartridge
body opening in which the female contact is disposed.

21. The cartridge of claim 11, wherein said opposite
contact ends of the cartridge contact members are male
contacts, and wherein the first contact ends of the first
insulative body terminals are female contacts.

22. A method of making a cable end plug assembly for
removably electrically connecting a tow vehicle to a towed
vehicle comprising:

providing a cable having a nonconductive covering
that surrounds a plurality of conductive wires, wherein each
wire comprises a separate nonconductive covering:

removing a portion of the cable covering to expose a
portion of the wire coverings:

removing a portion of each wire covering to expose a
portion of each wire:

mechanically and electrically connecting a
corresponding terminal to each wire;

attaching each terminal to a corresponding
attachment site on a mold load bar to space and orient the
terminals in a particular arrangement;

overmolding an insulative body to the terminals and
a portion of the cable, such that the terminals and the
overmolded portion of the cable are embedded in the insulative
body;

removing the load bar from the terminals, such that
the overmolded insulative body forms a first moiety of an

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internal first connector of the plug assembly;

5 providing a removable cartridge having a first end
that forms a second moiety of the internal first connector and
a second end that forms a socket-type moiety of a second
electrical connector.

10 23. The method of claim 22, wherein the first end of the
insulative body forms a plug-type moiety substantially in
conformity with SAE J560, the first end of the cartridge body
forms a plug-type moiety in conformity with SAE J560 and the
second end of the cartridge body forms a socket-type moiety
substantially in conformity with SAE J560.

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24. The method of claim 22, wherein mechanically and
electrically connecting a terminal to each wire comprises
crimping a second arm of the terminal to each corresponding
wire.

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25. The method of claim 24, wherein mechanically and
electrically connecting a terminal to each wire comprises
crimping a first arm of the terminal to each corresponding
wire covering.

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26. The method of claim 24, wherein mechanically and
electrically connecting a terminal to each wire comprises spot
soldering a portion of the terminal to each corresponding
wire.

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27. The method of claim 22, wherein providing a
removable cartridge includes:

 providing a cartridge body having the first end
and the second end and a plurality of openings extending from

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the first end to the second end;

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providing a common contact member having a female contact end and an opposite contact end;

inserting the common contact member in a corresponding one of the plurality of openings, such that the female contact end is disposed in and the opposite contact end extends from the corresponding cartridge opening;

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providing a plurality of noncommon contact members each having a female contact end and an opposite contact end;

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inserting each noncommon contact in a corresponding one of the plurality of openings, such that the female contact end is disposed in and the opposite contact end extends from the corresponding cartridge opening, wherein the female contact end of each contact member has an outer diameter that is smaller than an inner diameter of the corresponding cartridge opening in which it is disposed to allow for a lateral movement of the female contact end within the cartridge body.

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28. The method of claim 22, further comprising moveably attaching a housing to the cable before the overmolding of the insulative body to the cable, wherein the housing removeably houses the insulative body and a portion of the cartridge.

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